

Date: Monday, 25/05/2009 1:30:32 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : A119 STEP INSTALLATION R/H  
 Job Number : 48175  
 Estimate Number : 10132  
 P.O. Number :  
 This Issue : 25/05/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D119675012  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : N/A  
 Previous Run : 46572 Drawing Revision : N/A  
 Written By : Due Date : 10/06/2009 Qty: 6 Um: Each  
 Checked & Approved By : JUD 09-0525  
 Comment : Est Rev:D Removed Manufacturing JLM 05-11-01  
 Est Rev:E change to rev.b as per ECN1107 DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



*H fa JUD 09/06/11*



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP 119-675-012 CHG003

*8096663*

2.0 48175A A119 STEP WELDMENT RH



*S* Comment: Sub-Component A119 STEP WELDMENT RH

*x6 RH* 1 x D3043-042 Batch 48175A *SP*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

4.0 D2182B032 Rubber Cushion



*S* Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 4 D2182B032 Rubber Cushion 45405

*measured 5.16/15*

*88 09/06/15 (x6)*

5.0 D2274 Radius Block



*S* Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 8 D2274 Radius Block B477796

*88 09/06/15 (x6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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6.0	D26173	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing

B46606

SS 09/06/15 (X6)

7.0	D26175	Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing

B48186

SS 09/06/15 (X6)

8.0	D2732	Rubber Extrusion
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Comment: Qty.: 1.0660 f(s)/Unit Total : 6.3960 f(s)

Qty Part #

4 D2732-032

Description Batch

Rubber cushion

38509

measured 8/6/15

SS 09/06/15 (X6)

9.0	D30411	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3041-1 Clamp

B48185 15X / 46614 9X

B48185 15X / 46614 9X

SS 09/06/15 (X6)

10.0	D30413	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp

46615

SS 09/06/15 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

11.0

D30421

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3042-1 Clamp

48241

12.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt

M111193

13.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt

M106605

14.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

M110399

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M111279

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

1 paperwork package from Step 1

M110507

88 09/06/15 (18)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

201/06/23 (16/24)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

Location:

82 RWC 9/6/23

52

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 7/8

Job Completion



C209/06/24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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